

# Work Order ID 82956

Wednesday, April 11, 2012 3:14:44 PM

**\*82956\***

Page 1

Item ID: DSK081 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: D2940-1 TURNING DETAIL  
 Start Date: 4/11/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 4/26/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12/04/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
DSK081	B								
100	<i>Doosan</i> MORI SEIKI CNC LATHE LARGE	0.00				10	0		
<b>*100*</b>									
Doosan	Memo	0.00							
Doosan Lathe	Turn blank as per Folio FA079		<i>[Signature]</i>	12/4/20!					
110	QC2- Inspect parts off machine FAI/FAIB	0.00				10	0		
<b>*110*</b>									
QC	Memo	0.00							
Quality Control			<i>[Signature]</i>	12/4/20!					
120	QC8- Inspect parts - second check	0.00				10	0		
<b>*120*</b>									
QC	Memo	0.00							
Quality Control			<i>[Signature]</i>	12.4.22					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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\*82956\*


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Wednesday, April 11, 2012 3:14:44 PM

Item ID: DSK081 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: D2940-1 TURNING DETAIL  
Start Date: 4/11/2012 Start Qty: 10.00 \*10\* Cust Item ID:  
Required Date: 4/26/2012 Req'd Qty: 10.00 \*10\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
*130*									
Packaging	Memo	0.00							
Packaging	Identify and Stock in KanbanLocation: <u>CNC</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

12/4/23   
112-04-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, April 11, 2012 3:14:47 PM

Page 1

Work Order ID: 82956

**\*82956\***

Parent Item: DSK081

**\*DSK081\***

Parent Item Name: D2940-1 TURNING DETAIL

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-007		Manufactured	No				Each	18.0000		10			
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**\*D6104-007\***

Round Billet, 17-4

~~\*\*\*~~\*\*

SA 10/4/11 9

Location

Loc Qty

Loc Code

MAT043

6

76833

6

MAT047

12

77492

2

80115

10

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	82954
<b>Description:</b> Turning Detail for D2940-1		<b>Part Number:</b>	DSK081
<b>Inspection Dwg:</b> DSK081		<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.215	3.216	3.216	3.216	3.216
B	4.946	4.966		4.953	4.956	4.956	4.956	4.956
C	0.718	0.738		.728	.728	.728	.728	.728
D	0.090	0.110		.100	.100	.101	.101	.100
E	3.564	3.584		3.571	3.573	3.573	3.574	3.574
F	0.022	0.042		.031	.031	.031	.031	.031
G	3.444	3.464		3.461	3.463	3.463	3.463	3.463
H	0.112	0.132		.130	.129	.125	.128	.128
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.457	4.460	4.460	4.458	4.458
K	0.413	0.433		.430	.430	.430	.430	.430
L	0.913	0.933		.930	.928	.928	.928	.928
M								
N								
O								
P								

Measured by: SA Date: 12/4/20

Audited by: REP Date: 12-4-22

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>SA</u>

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	82956
<b>Description:</b> Turning Detail for D2940-1		<b>Part Number:</b>	DSK081
<b>Inspection Dwg:</b> DSK081		<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.956	4.956	4.956	4.956	4.956
C	0.718	0.738		.728	.728	.728	.728	.728
D	0.090	0.110		.103	.102	.103	.103	.103
E	3.564	3.584		3.572	3.571	3.574	3.572	3.575
F	0.022	0.042		.031	.031	.031	.031	.031
G	3.444	3.464		3.462	3.461	3.464	3.462	3.463
H	0.112	0.132		.128	.127	.128	.128	.128
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.460	4.457	4.455	4.458	4.458
K	0.413	0.433		.430	.430	.430	.430	.430
L	0.913	0.933		.928	.928	.928	.928	.928
M								
N								
O								
P								

Measured by: SA Date: 12/4/20

Audited by: TR Date: 12-4-22

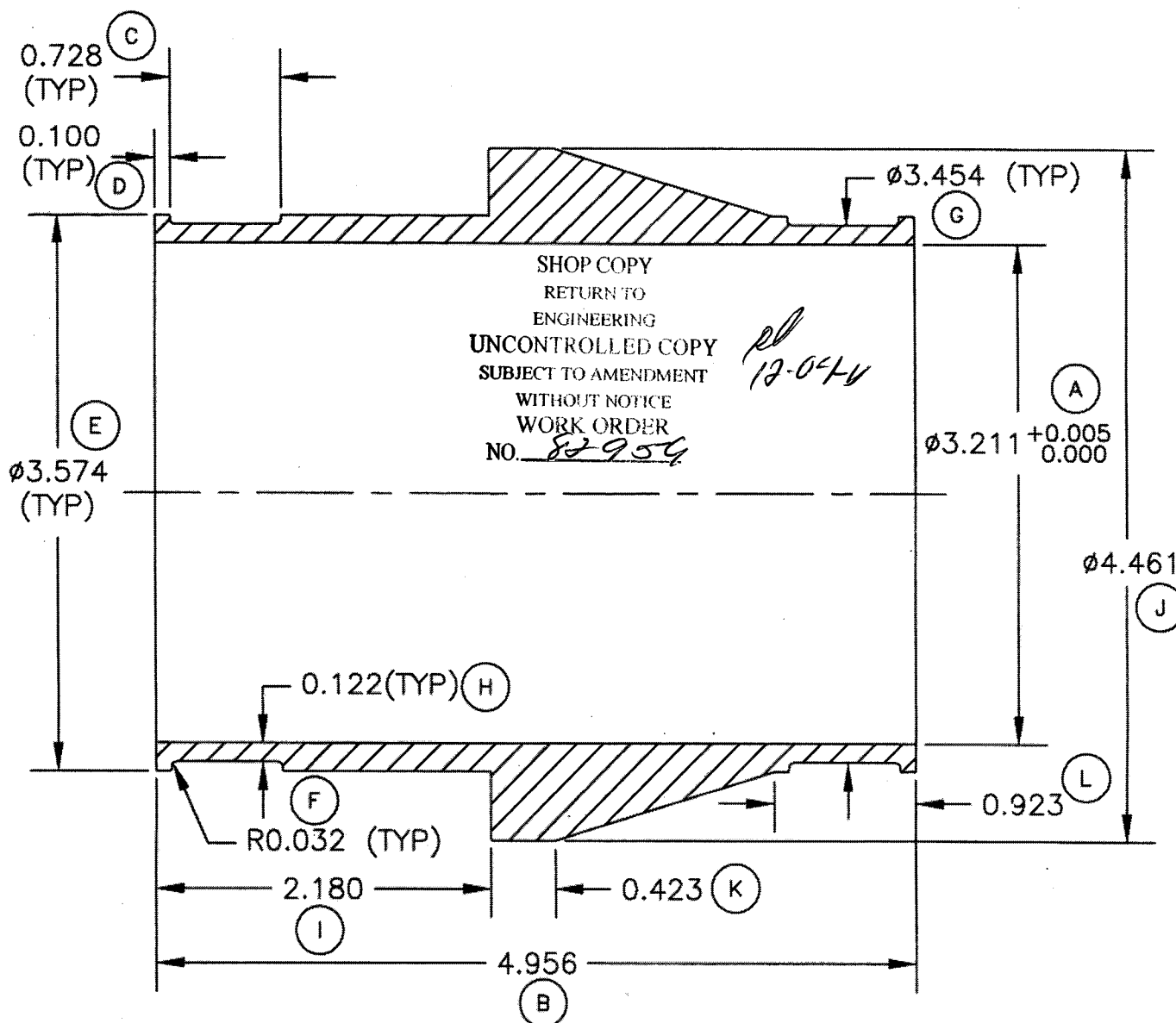
Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>SA</u>



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED  
03.07.01 *[Signature]*



D2940-1 TURNING DETAIL

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries